

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010160**Date Inspected:** 02-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen fu you / Lv liqing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 3F-129 located on PCMK SSD22-PP75.5 of 9BW welder is identified as 201215. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4133.

SMAW welding of weld joint 4G-024 located on PCMK SEG063A of 10CW welder is identified as 045246. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

During in process inspection it is found that 12mm root gap of fillet weld joint connecting deck plate to Corner section(CSD) in segment 9BW the weld no is identified as SSD22-PP75.5-123/124, checked with ABF QA Mr. Lihao and informed to ZPMC QC Mr.Xu tao, he agreed and recorded to convert into CJP and Engineer's approval.

BAY#13

FCAW welding of weld joint 1G-008 located on PCMK SSD19-PP102 of 11CE welder is identified as 055560. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint 4G-073 located on PCMK SP635-001 of 11BE welder is identified as 067750. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

ZPMC QC check the fit-up of Fillet weld joint in OBG assembly which ever root gap exceeding more than 5mm, they recording and documenting all those for engineer's approval and follow up further NDT for convert into CJP, they document in the form 787-B-QCR-402.

Segment 11BE , Corner assembly CA084

CSD5-PP99-063/064,065/066.

CSD5-PP99.5-049/050,053/054.

CSD4-PP100-147/148.

Segment 11CW, corner assembly CA085

CSD9-PP102-143/144,065/066.

BAY#19

FCAW welding of weld joint 2F-009 located on PCMK BP026-010 welder is identified as 062752.ZPMC QC is identified as Mr.Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

SAW welding of weld joint 1G-003 located on PCMK BP026-012 welder is identified as 062816.ZPMC C QC is identified as Mr.Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

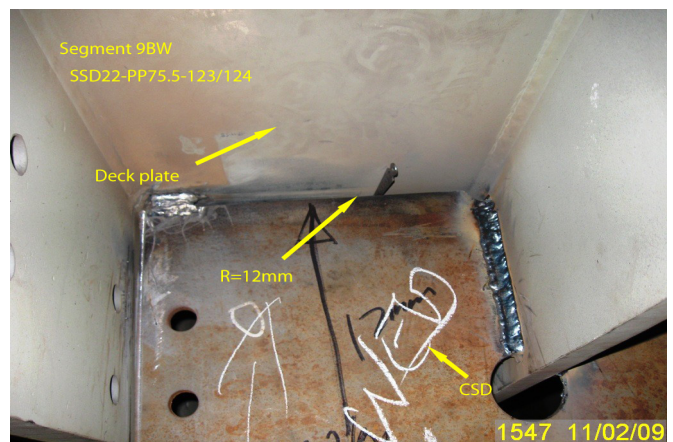
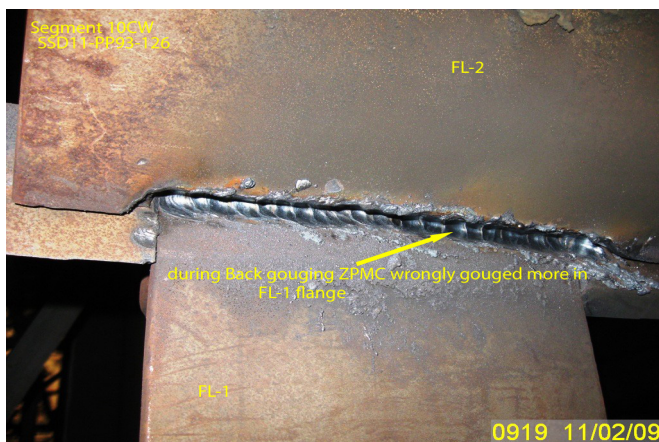
OUTSIDE SEGMENT

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Segment 7BE. The weld designations reviewed are as follows:

EP079-021,022,025.

SSD18A-PP52-004,005.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant Conversation.

Item	Description	WBS	Dwg No.	Status
1				
2				

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
